


Date: Thursday, 2/7/2008 11:56:16 AM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : COVER PLATE
 Job Number : 37294
 Estimate Number : 13165
 P.O. Number :
 This Issue : 2/7/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : R & D SM/MED FAB
 Previous Run :
 Written By : 
 Checked & Approved By :
 Comment : Est Rev:A 08-01-30 new issue EC verified by:DD

Part Number : D37053
 Drawing Number : D3705 U/R
 Project Number : N/A
 Drawing Revision : U/R 08.02.06
 Material :
 Due Date : 2/14/2008 Qty: 2 Um: Each

PROTOTYPE

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.7466 sf(s)/Unit Total: 1.4931 sf(s)

6061T6 aluminium sheet .080" thick

(M6061T6S080)

Batch: 106320 LB 8-2-7

CERTIFICATE OF CONFORMITY
REQUIRED

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3705

Dwg Rev: 4/2 LB 8-2-7

Prog Rev: 4/2

2- Deburr if necessary LB 8-2-7

2

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

LB 8-2-7

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

12080207

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- BEND AS PER DWG D3705

08.02.07

Date: Thursday, 2/7/2008 11:56:16 AM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER PLATE

Job Number: 37294

Part Number: D37053

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



102.08.02

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ~~ES~~

FOR ENGINEERING USE ONLY

102.08.20

8.0

QC21

FINAL INSPECTION/W/O RELEASE



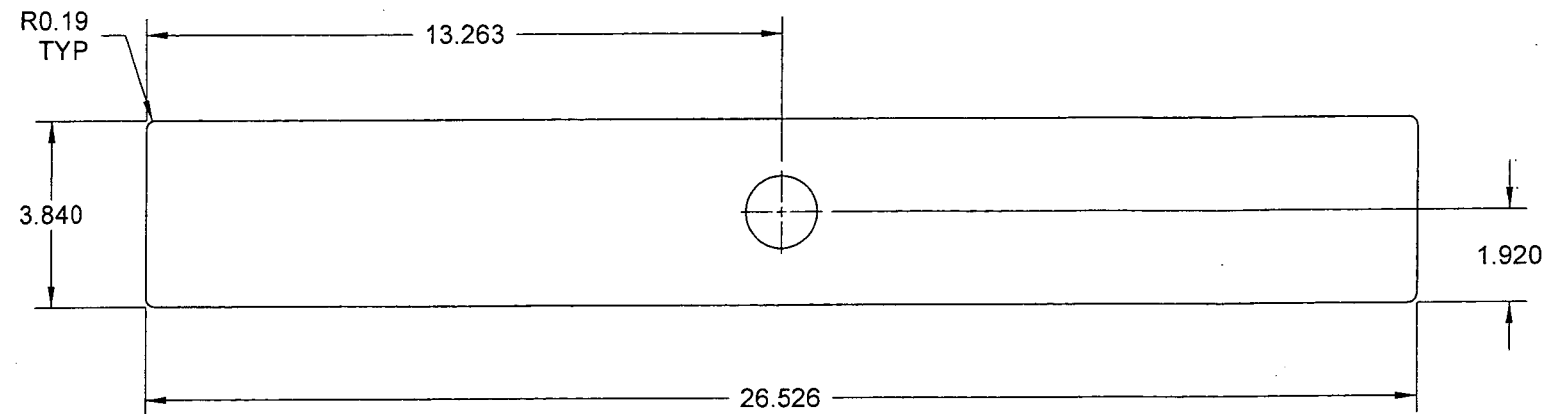
10.08.0605
Promtype
102.08.05.00

Comment: FINAL INSPECTION/W/O RELEASE

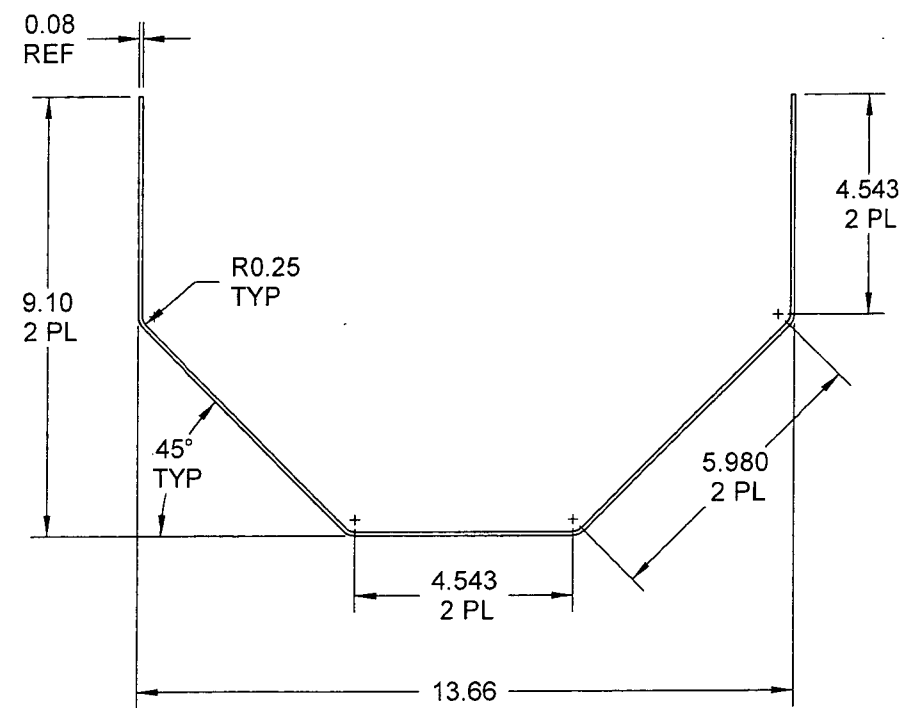
Job Completion



mf 08-05-16



1 D3705-3F COVER PLATE FLAT PATTERN



D3705-3 COVER PLATE
(MAKE FROM D3705-3F)


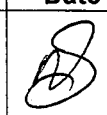
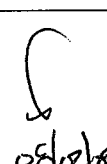

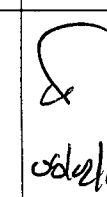
PROTOTYPE
PLEASE RETURN ALL ISSUED
PARTS TO ENGINEERING
FOR RE-EVALUATION

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3705	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER PLATE	1:4
DATE	08.02.06	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/08	15	one part SCRAP. D3765-3 was deformed during Bending. Re. Hammer end	 Q51042	SCRAP and destroy. no replace Qty (+1)	 08/02/08	 08/02/08	 08/02/08	 08/02/08

NOTE: Date & initial all entries

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Comment: Qty.: 0.7466 sf(s)/Unit Total: 1.4931 sf(s)
 6061T6 aluminium sheet .080" thick
 (M6061T6S080)
 Batch: 106320 IB 8-2-7

CERTIFICATE OF CONFORMITY
 REQUIRED

Magna.
 P/O: 5024

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3705

Dwg Rev: UR IB 8-2-7

Prog Rev: UR

2- Deburr if necessary IB 8-2-7

2

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- BEND AS PER DWG D3705

IB 08-02-07

Receiving Report

Date: 7/11/21
 Supplier: MAGNA

Batch No: M106320
 Dart P/O: 5024

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☐ No ☒ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection Alu 121 N/A ☒
 Work Order N/A ☐

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin: 07/11/21
 Date RLP 6099
 Received/Costing GZ
 Initial

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

Sub-Total
 G.S.T.

2460.00
 147.60

TOTAL →

2607.60

FRAIS D'ADMINISTRATION DE 1½% PAR MOIS (18% PAR ANNÉE) SUR COMPTE PASSÉ DÙ.
 LE PRÉSENT CONTRAT SERA RÉGI PAR LES LOIS DE LA PROVINCE DE QUÉBEC ET COMME
 AYANT PRIS NAISSANCE DANS LE DISTRICT JUDICIAIRE DE MONTRÉAL.
 ADMINISTRATION CHARGES OF 1½% PER MONTH (18% PER YEAR) ON OVERDUE ACCOUNTS.
 THE PRESENT AGREEMENT SHOULD BE GOVERNED BY THE QUEBEC LEGISLATION AND SHOULD
 BE CONSIDERED AS HAVING ORIGINATED IN THE JUDICIAL DISTRICT OF MONTREAL.

002/003

002/003

11/21/2007 WED 8:24 FAX 613 632 4443 DART HELICOPTER SERVICES → DAS - LINDA

11/21/2007 WED 8:15 FAX 514 631 2202 Magna J Palmer

CB 677

DOC : V/0000250810

DATE : 2007-09-27

PROD. REP. : 0000227875/002

WRST : 14906/02

PAGE : 1/ 2

INSPECTION CERTIFICATE

Aleris

Europe

Aleris Aluminum Duffel BVBA
A. Soderström 67, 2240 Duffel - Belgium
Tel. 02 (0) 76 80 21 11 - Fax (0) 76 80 27 04

CUSTOMER : ALERIS ROLLED PRODUCTS

1700 EASTPOINT PARKWAY, SUITE 200
LOUISVILLE, KY 40221 USA

YOUR ORDER NUMBER : 400894-IMP (YARDS PORT0608DN002)
OUR ORDER NUMBER : 14906/02
DOCUMENT NUMBER : V/0000250810

DESCRIPTION : ALU SHEETS (STENC.) AA 6061-T6 AMS-QDA-250/11 AMS 4027M ASTM B209-04
DIMENSIONS : 144" X 48" X .08"
ARTICLE NO. :

CHEMICAL COMPOSITION (%)

COIL NUMBER	CAST NUMBER	SI	FE	CU	MN	MG	CR	TI	ZN
		MIN							
		MAX							
001	1464441	0.60	0.7	0.15	0.15	0.8	0.04	0.18	0.25
		0.6		0.40		1.2	0.35		
		0.62	0.4	0.20	0.08	1.0	0.16	0.02	0.08

OTHERS : EACH : MIN 0.05 MAX
TOTAL : MIN 0.15 MAX

MECHANICAL PROPERTIES

TEST - NUMBER	1 N/A12 = 1 MPa = 0.1 NBAR	1 N/A12 = 1 MPa = 0.1 NBAR	1 N/A12 = 1 MPa = 0.1 NBAR	1 N/A12 = 1 MPa = 0.1 NBAR
	/A = REAR END	/M = MIDDLE	/F = FRONT END	/C = RANDOM SAMPLING
	MIN	MAX	MIN	MAX
001	48	48	48	48
001	48	48	48	48
001	48	48	48	48

OCT 25 2007

BY *M. L. Lippert*
HELISSA GARNER CERTIFICATION PROCESSOR

Aleris Aluminum Duffel BVBA

Inc 11-20-07

ORIGINAL DISTRICT OF MONTREAL

11/21/2007 WED 8:24 FAX 613 632 4443 DART HELICOPTER SERVICES →→→ DAS - LINDA
 11/21/2007 WED 8:16 FAX 5146312202 Magna - J Palmer

003/003

003/003

Aleris
 Europe

DOC : V/008250860 DATE : 3007-03-31 PROD. REF. : 000227975/003 KRIST : 14906/02 PAGE : 2 / 2

Aleris Aluminium Duffel BVBA
 A. Stuyver 61, 1000 Duffel - Belgium
 Tel 32 (0)3 2021 11 - Fax 03 2022 34

DATE SOLUTION HEAT TREATMENT COIL NUMBER
 001 STRENGTHENING : WEEK 35 / YEAR 2007
 SEND OF LABORATORY
 EXOTER SCHWELDEN



Aleris Aluminium Duffel BVBA